

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029815**Date Inspected:** 16-Jul-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Jesus Cayabyab**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QA) Joe Adame arrived at the American Bridge/Fluor (ABF) job site between the times noted above in order to monitor ABF Quality Control functions and the in work being performed by ABF personnel. The following items were observed:

Repair Verification-

RWR-201306-002

ESW E-043-"Q":

The QA Inspector observed at ABF Quality Control Inspector (QC) Jesse Cayabyab performing Magnetic Particle Testing (MT) verification of ESW weld repair excavation prior to welding. Location of the repair was noted as:

ESW E-043 "Q" Face A

Y= 5400mm~5560mm

Repair length-160mm

Repair width-65mm

Repair depth-60mm

QA also performed a MT verification of the repair excavation and did not observe any discontinuities. The QC Inspector stated that ABF welder Don Plumb (WID-0891) would commence preheat and be performing the repair welding at this location. See TL-6028 for additional information on items inspected on this date.

Exploratory excavation

ESW S-045,"G"-Face A:

The QA Inspector was present to observe ABF welder Kit Lai (WID-2953) performing exploratory excavation of

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ESW "G" Face A @ Y-9490mm to verify indications observed during Ultrasonic Testing pulse/echo & pitch/catch.

QC Inspector Jesse Cayayab stated that Mr. Lai will excavate every 5mm deep and allow QC/QA to inspect the excavation. After grinding to bright metal the QC Inspector performed MT testing of the excavation to inspect for planar indications at each hold point. The QA Inspector also performed MT inspection throughout the process and the final excavation. Location of the planar indication observed in the excavation was:

ESW "G", Face A

Indication first discovered at Y= (Original) 9490mm, actual Y-9500, X= -15

Indication visible at: 18mm deep, 30mm long

Indication visible at: 25mm deep, 35mm long

Indication visible at: 28mm deep, 35mm long

Indication visible at: 31mm deep, 35mm long

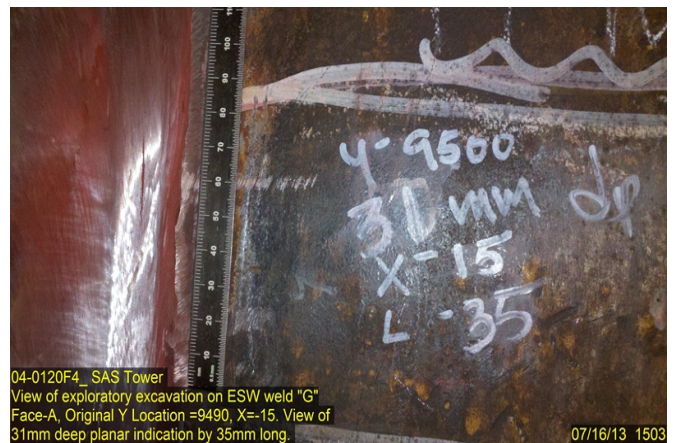
Indication visible at: 34mm deep, 10mm long

Indication visible at: 36mm deep, 2mm long

Indication removed at: 38 mm deep

Final excavation Y=9400mm~9620mm, Length=220mm, Width=50mm & Depth=38mm.

ABF QC Representative Chris Chew stated that ABF do not have approval to weld the ESW PC excavation locations at this time and will only be excavating to verify the indications and remove them. The QA/QC Inspectors did verify that the planar type indication was removed on this shift. See TL-6028 for additional details on items inspected.



Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to work and testing performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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Inspected By:	Adame,Joe	Quality Assurance Inspector
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Reviewed By:	Mertz,Robert	QA Reviewer
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